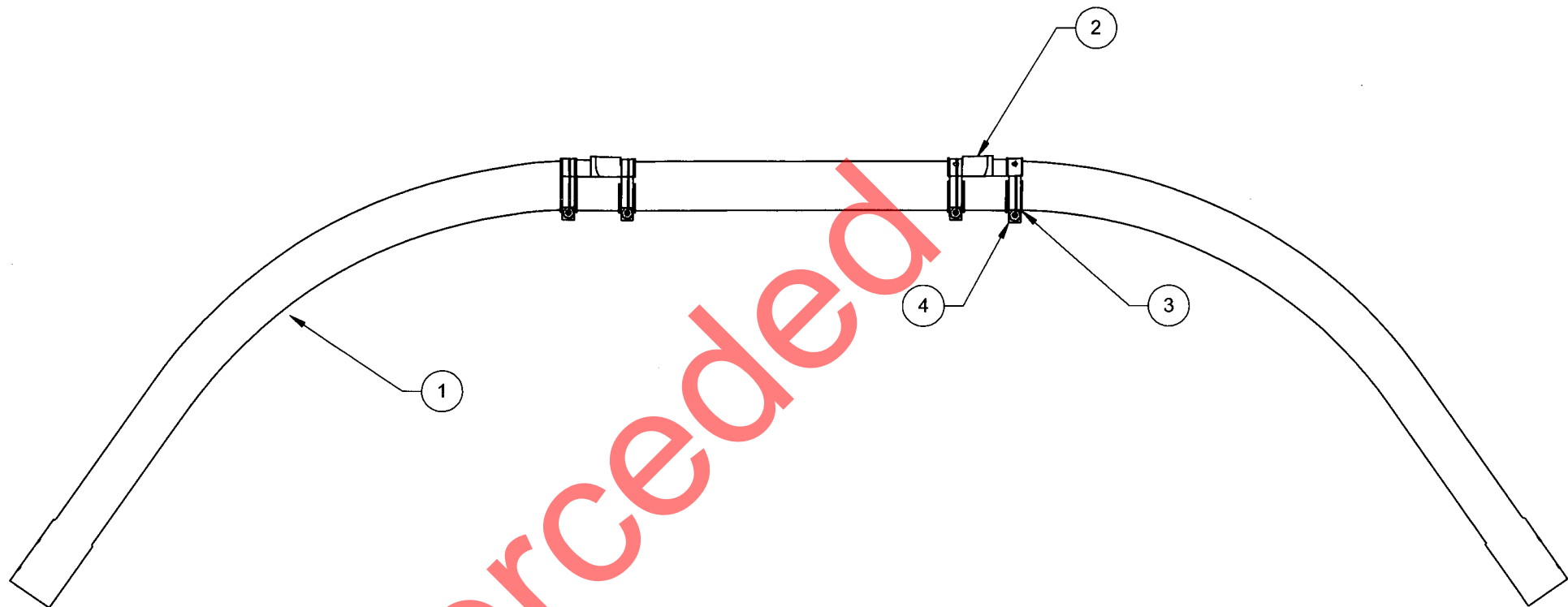


ITEM	QTY -141	P/N	DESCRIPTION
	X	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141BND	CROSSTUBE, FWD
2	2	D5124-1	FWD SUPPORT
3	4	D5123-3	CLAMP CUSHION
4	4	MS21920-24	CLAMP



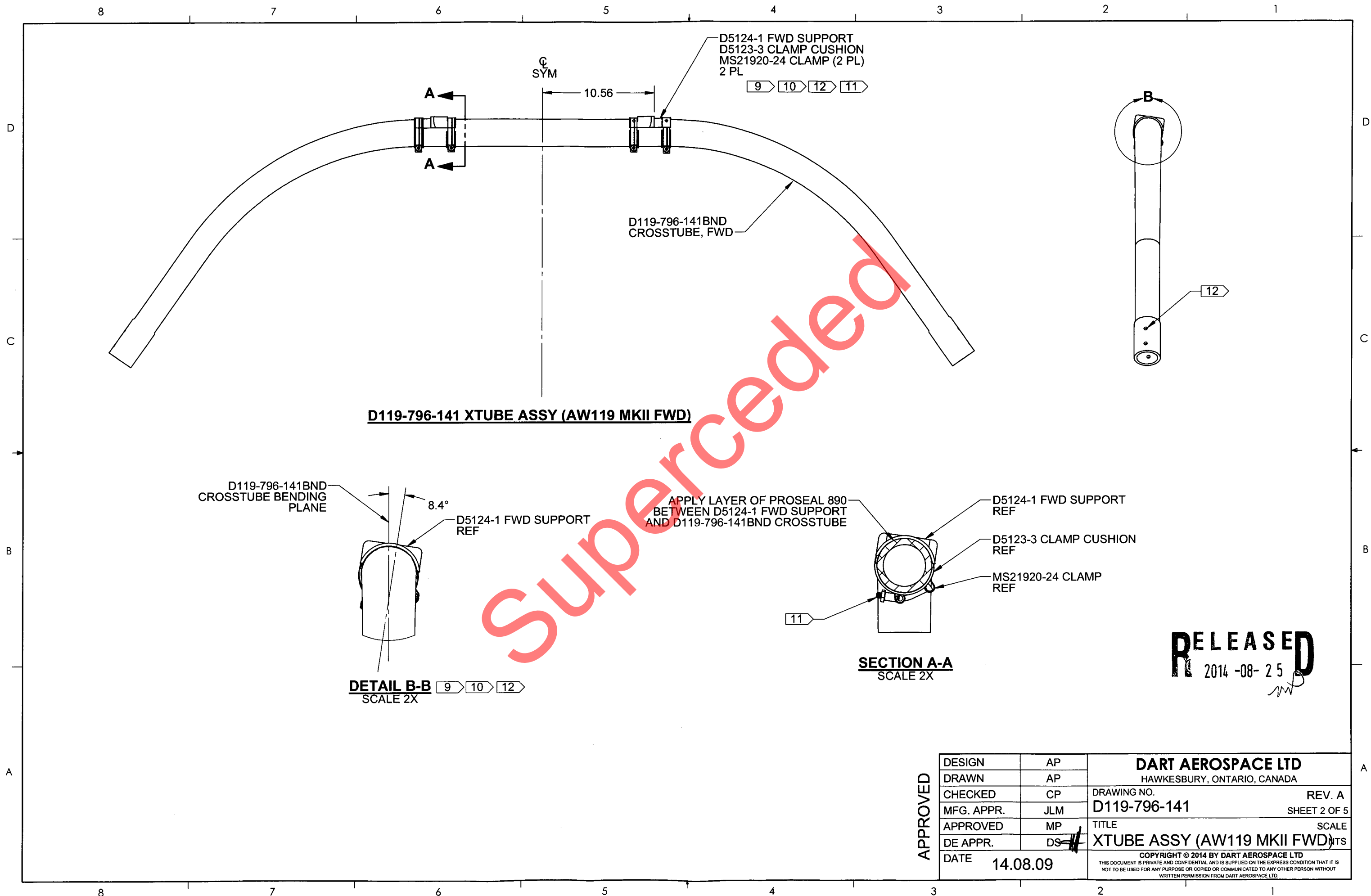
D119-796-141 XTUBE ASSY (AW119 MKII FWD)

NOTES:

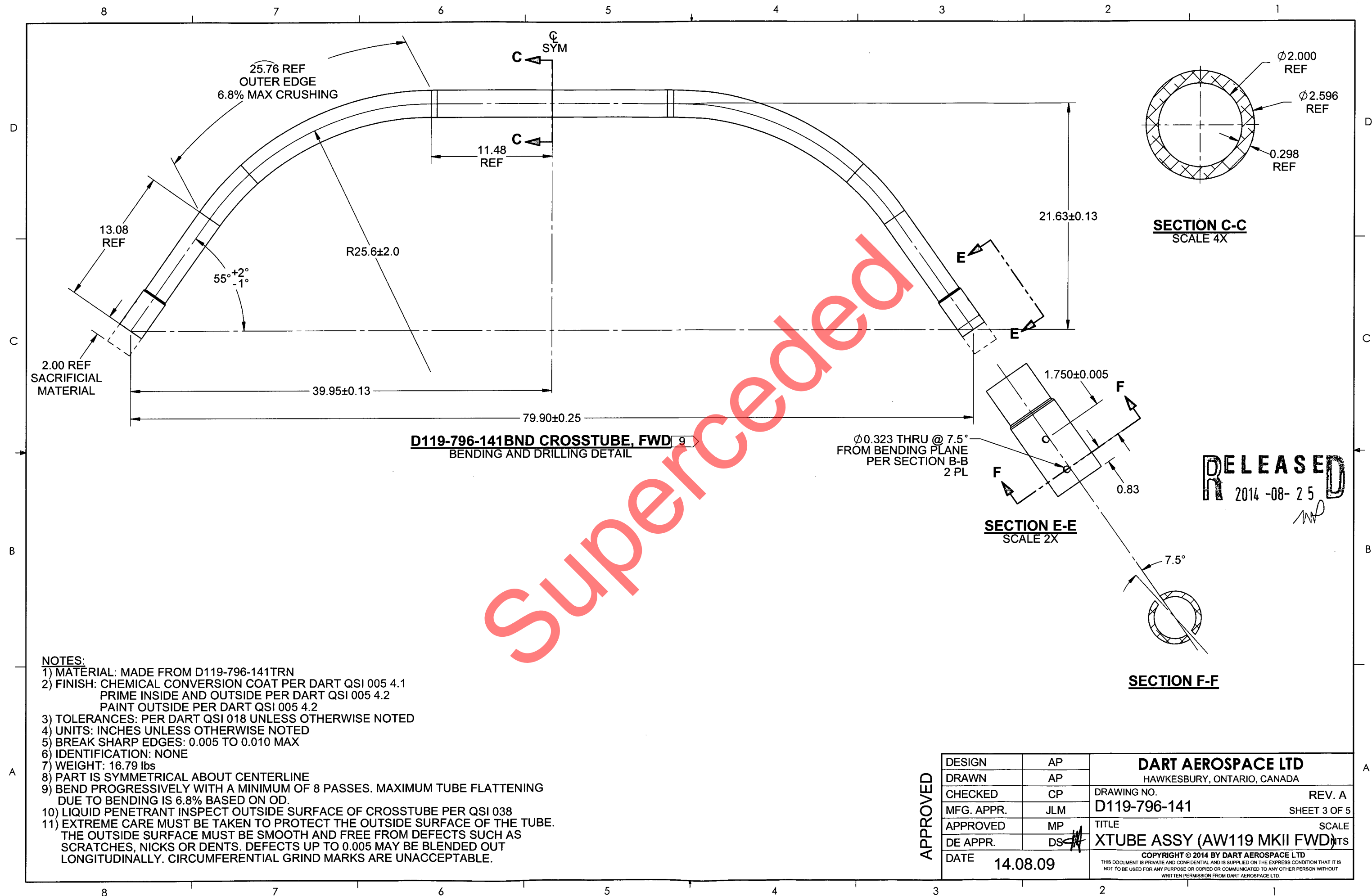
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-141" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 18.00 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) INSTALL MS21920 CLAMPS USING D5123-3 CLAMP CUSHIONS OFFSET AT 8.4° FROM CROSSTUBE BENDING PLANE. ENSURE THAT THE CLAMP TIGHTENING MECHANISM IS AT 90° TO THE CROSSTUBE BENDING PLANE AND THE NUTS FACE AFT.
- 10) APPLY A LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5124-1 FWD SUPPORTS AND INSTALL AT AN 8.4° OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL THE MS21920-24 CLAMPS AND D5123-3 CLAMP CUSHIONS WHILE WET. ENSURE OFFSET IS AS PER NOTE 12.
- 11) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 12) THE D5124-1 FWD SUPPORT AND D5123-3 CLAMP CUSHIONS MUST ALL BE ORIENTED AT 8.4° TO THE CROSSTUBE BENDING PLANE. THE DIRECTION OF THE OFFSET IS DIRECTLY RELATED TO THE CUFF THRU HOLES. REFER TO SHEET 2 FOR DETAILS.

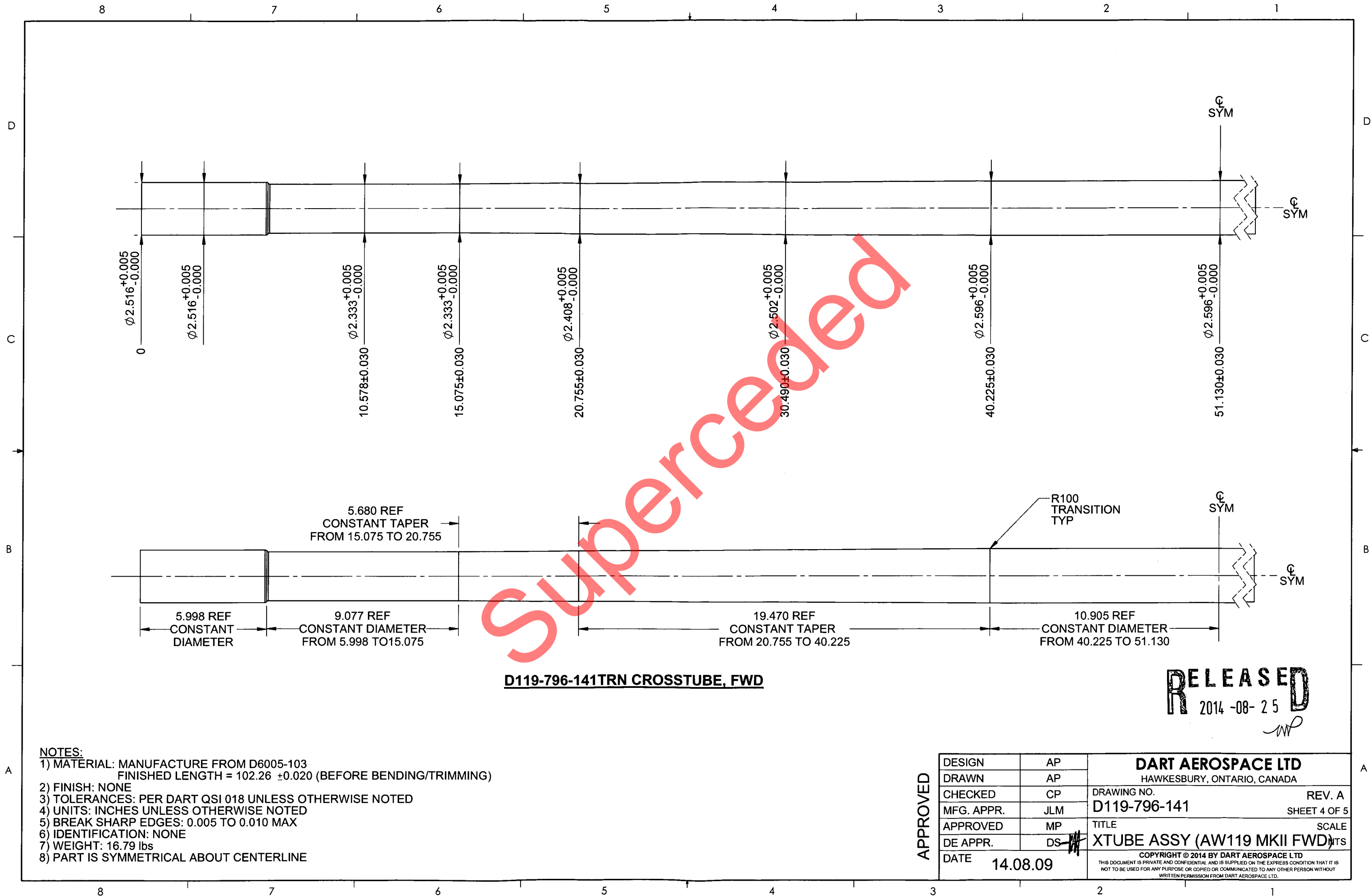
RELEASED
2014-08-25

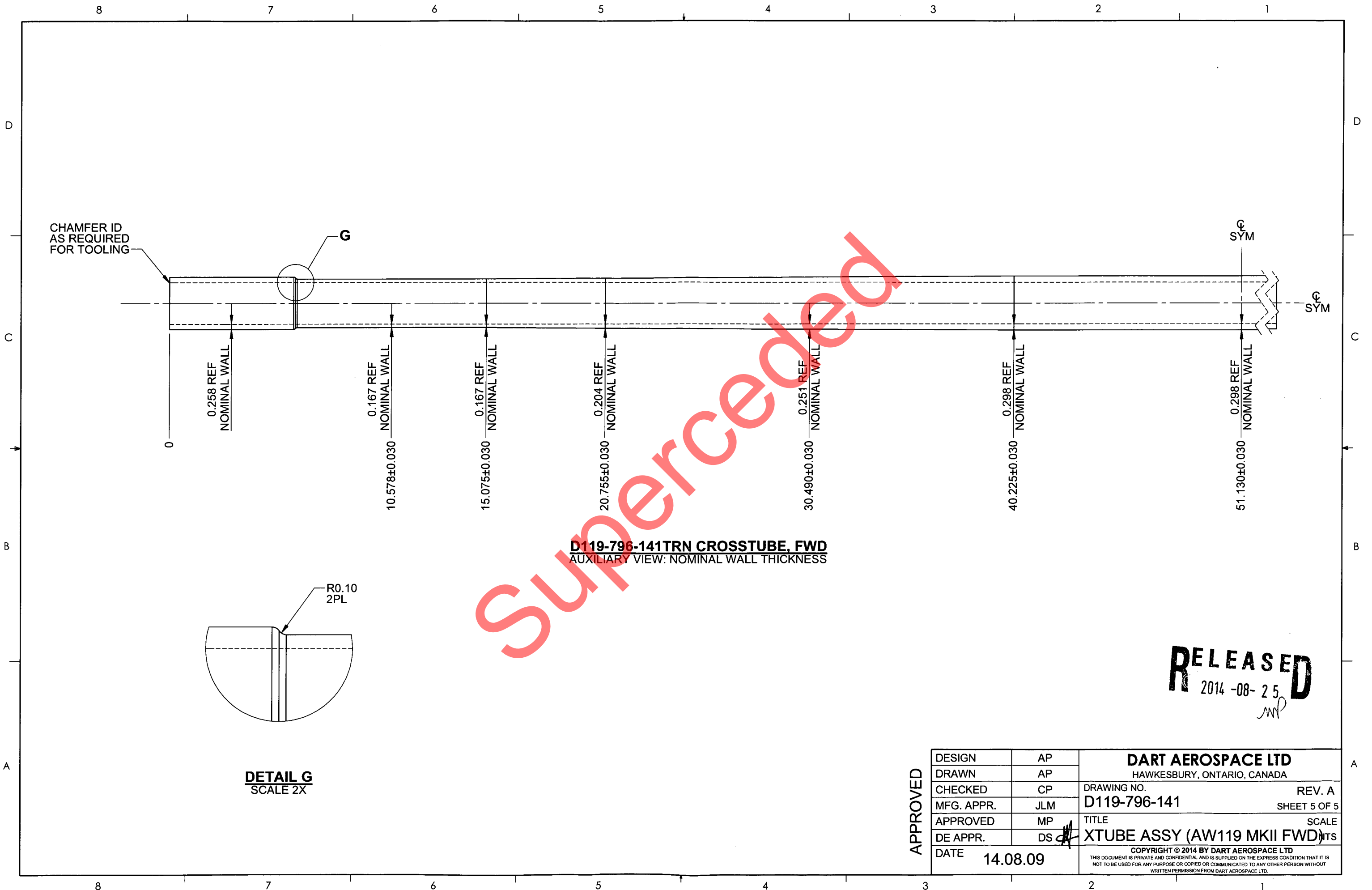
A	NEW ISSUE	AP	14.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D119-796-141	SHEET 1 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NITS
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	MFG. APPR.	JLM	D119-796-141	SHEET 2 OF 5
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	ITS
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CHAMFER ID
AS REQUIRED
FOR TOOLING

G

C
SYM

C
SYM

0.258 REF
NOMINAL WALL

0.167 REF
NOMINAL WALL
10.578±0.030

0.167 REF
NOMINAL WALL
15.075±0.030

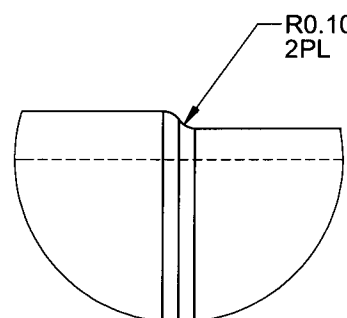
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NOMINAL WALL
20.755±0.030

0.251 REF
NOMINAL WALL
30.490±0.030

0.298 REF
NOMINAL WALL
40.225±0.030

0.298 REF
NOMINAL WALL
51.130±0.030

D119-796-141TRN CROSSTUBE, FWD
AUXILIARY VIEW: NOMINAL WALL THICKNESS



DETAIL G
SCALE 2X

RELEASED
2014-08-25
MP

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CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D119-796-141	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII FWD)	NTS
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